

Date: Thursday, 28/09/2006 10:54:00 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D206667203A  
 Job Number : 28752  
 Estimate Number : 10804  
 P.O. Number : N/A  
 This Issue : 28/09/2006 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : 28/09/2006 Type : OVERHEAD  
 Previous Run : 00015  
 Written By :  
 Checked & Approved By :  
 Comment : chg 001

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D206667203A	Crosstube Installation W/ armour shield



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 Crosstube Installation W/ armour shield  
 ORIGINAL B/N 27981

2.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT RTN 509

206-05-28 (1)

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1  
 -DRILL OUT RIVETS AND REMOVE NUTPLATES  
 RECORD NUTPLATE P/N  
 -DRILL EXTRA HOLES AS PER DSI 9346  
 -DEBURR & TOUCH UP WITH ALODINE

} Pmc/DP 2-3-26

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

207/03/26 (1)

5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1  
 INSTALL NUTPLATES  
 PER DSI 9346  
 RECORD P/N & B/N'S OF  
 NUT PLATES AND RIVETS  
 Re-install Support Label.

DP/DP

<b>DART</b>			
TRANSPORT CANADA APPROVAL 009-39			
P/N	D206-667-203A	CHG	CHG001
DESC	Crosstube Aft High	STC	SH01-5
L/CN	B27981	STC	SR01304NY
MODPL	Bell 206L/L1/L3/L4	STC	

TEL: 1-613-632-3336  
 FAX: 1-613-632-4443

Date: Wednesday, 25/04/2007 9:54:18 AM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206667203A

Job Number: 28752

Part Number: D206667203A

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.9

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING  
PRIME & PAINT CUFFS  
AS NECESSARY PER QSI 005

*see attached*

8.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
PICK KIT:

10.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Bolt  
Batch: *M101340* ✓

11.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Nut  
Batch: *M102536* ✓

12.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)  
Pick:Packing Kit  
Qty Part number Description Batch  
10 AN5-10A Bolt *M102328* ✓

Date: Wednesday, 25/04/2007 9:54:19 AM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206667203A

Job Number: 28752

Part Number: D206667203A

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	AN532A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt

M10215 ✓

14.0	AN960JD516	Washer
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Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M102519 ✓

PD.  
27/4/25 ✓

15.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

27/04/25

16.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

APPLY NEW LABELS (RED & WHITE)

AND NEW PAPERWORK

ENSURE KIT IS COMPLETE

DART 27/4/25 (1)

17.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

27/04/25 (1)

18.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

PACKAGE PER PPP

27.04.25

Job Completion



Date: Thursday, 28/09/2006 10:54:00 AM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206667203A

Job Number: 28752

Part Number: D206667203A

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*28/09/2006*

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING  
PRIME & PAINT CUFFS  
AS NECESSARY PER QSI 005

*37 07 - 04 - 24*

8.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

*28-09-25*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
APPLY NEW LABELS (RED & WHITE)  
AND NEW PAPERWORK  
ENSURE KIT IS COMPLETE

*see attached*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
PACKAGE PER PPP

Job Completion





DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9346	REV. A SHEET 1 OF 1
DATE 06.08.08		TITLE DEVIATION ON D206-667	SCALE NTS
A	06.08.08	NEW ISSUE	

## DART SERVICE INSTRUCTION

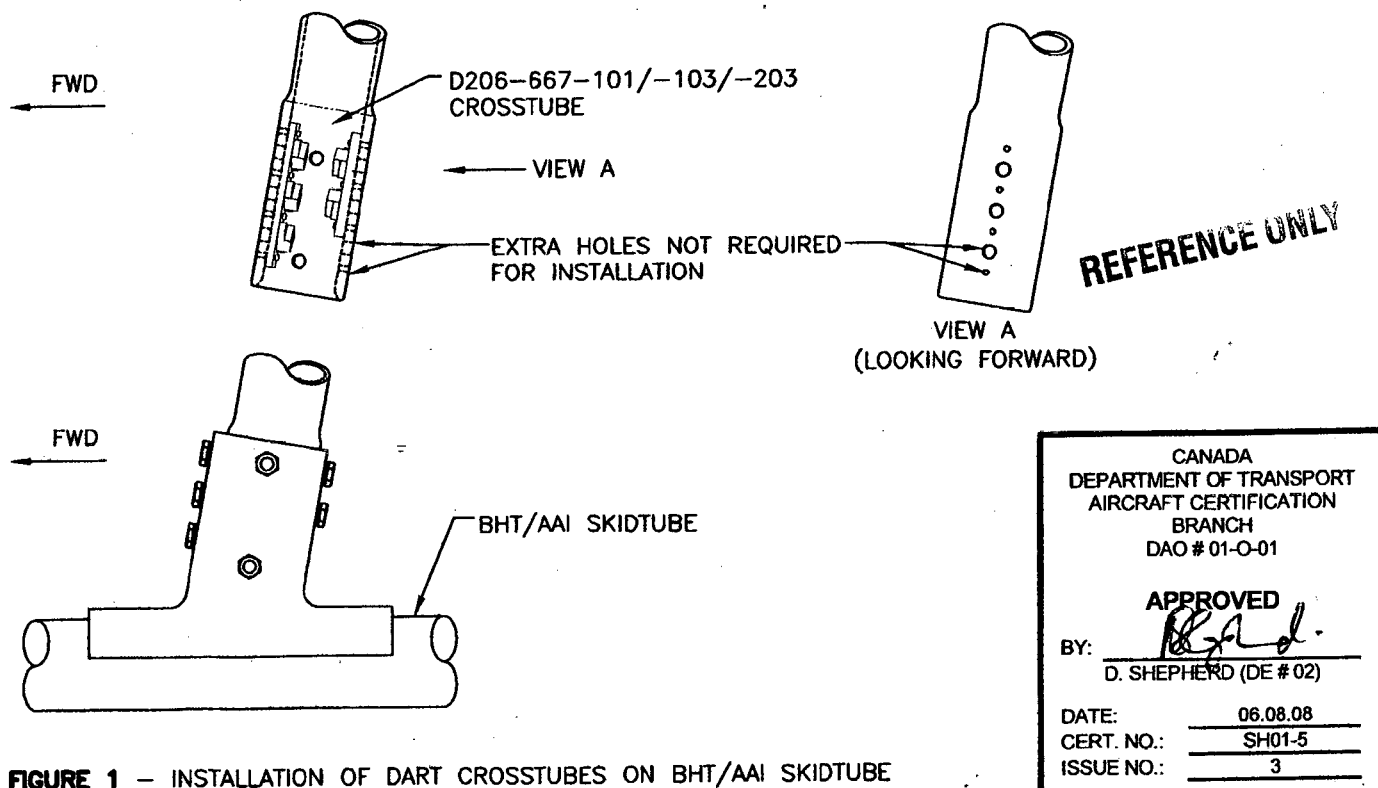
TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C  
REF. CANADIAN STC: SH01-5  
REF. FAA STC: SR01304NY

THE FOLLOWING D206-667-101/-103/-203 CROSSTUBES HAVE EXTRA HOLES DRILLED ON THE AFT SIDE OF THE CUFFS. THIS HOLE IS NOT REQUIRED FOR INSTALLATION OF DART CROSSTUBES ONTO BHT/AAI SKIDTUBES AS SHOWN IN FIGURE 1.

CUSTOMERS RECEIVING CROSSTUBES AT CHG 002 PRIOR TO 06.08.08 SHOULD CONTACT DART FOR DISPOSITION IF INSTALLING THE DART CROSSTUBES ONTO BHT/AAI SKIDTUBES PER IIN-D206-667 REV. C.

CUSTOMERS RECEIVING CROSSTUBES AT CHG 002 PRIOR TO 06.08.08 TO BE INSTALLED WITH DART SKIDTUBES MAY FIND THAT THE SUPPORTS HAVE BEEN INSTALLED BACKWARDS. THE SUPPORTS SHOULD BE REMOVED AND RE-INSTALLED PER ICA-D206-667.

PART NO.	CHANGE NUMBER	BATCH NO
D206-667-101	002	B24244
D206-667-103	002	B26702, B26704, B27980, B25606, B25605, B23220, B23219, B23218, B23217
D206-667-203	002	B27492, B27491, B27981, B25609, B25608, B25006, B24646



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/23	5.0	1 rivet was found to be unacceptable (stem broke off too far in the head). Upon removal, due to thicknesses, the hole in the nut plate oversized.	QSI04/2	Scrap & Replace D2873043 B31192 Rivets BMS20601AHW M100771	07/04/23	07/04/23	QSI04/2	07/04/23

NOTE: Date & initial all entries